

Work Order ID 71353

Tuesday, June 28, 2011 3:34:48 PM



Page 1

Item ID:	D3189-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Chafing Shield					
Start Date:	6/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/12/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CMF</u>	Date:	<u>11-06-28</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3189	Rev B								

100		0.00							
	SHEAR								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<u>304 - 022</u>	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Debur if necessary								
103		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-6-29

22

B11-6-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				Count (72)			
110 Small Fab Small Fab	Small Fab Memo 1-Debur & Grind Rads as per Dwg D3189 2-Roll as per Dwg D3189 3-Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DSI9549 and DEO D412-664-243.	0.00 0.00				(22)			
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				Count (72)			

SP 11/08/02

SP 11/08/02

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Tuesday, June 28, 2011 3:34:48 PM



Page 3

Item ID: D3189-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 6/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *X file*

0.00



Packaging

Memo

0.00

Packaging

85 11-11-28 22

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/28
UMF
11-11-28

Dart Aerospace Ltd

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Picklist Print

Tuesday, June 28, 2011 3:34:44 PM

Page 1

Work Order ID: 71353



Parent Item: D3189-1



Parent Item Name: Chafing Shield

Start Date: 6/28/2011

Required Date: 7/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B 05.08.22 No longer made in-house KJ/JLM
 IPP Rev:C 06-03-24 Rolling Now made in House JLM
 IPP Rev:D 07-04-16 As per Rev B JLM
 11.05.11 now made on waterjet DD verf:JLM

IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 		Purchased	No			100	sf	22.0000	0.32	6.736842	7.		
304/316 .020" Sheet										1811-6-29			

Location

MAT20

117285

Loc Qty

22

22

Loc Code

117285

22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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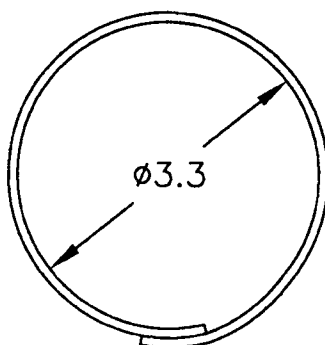
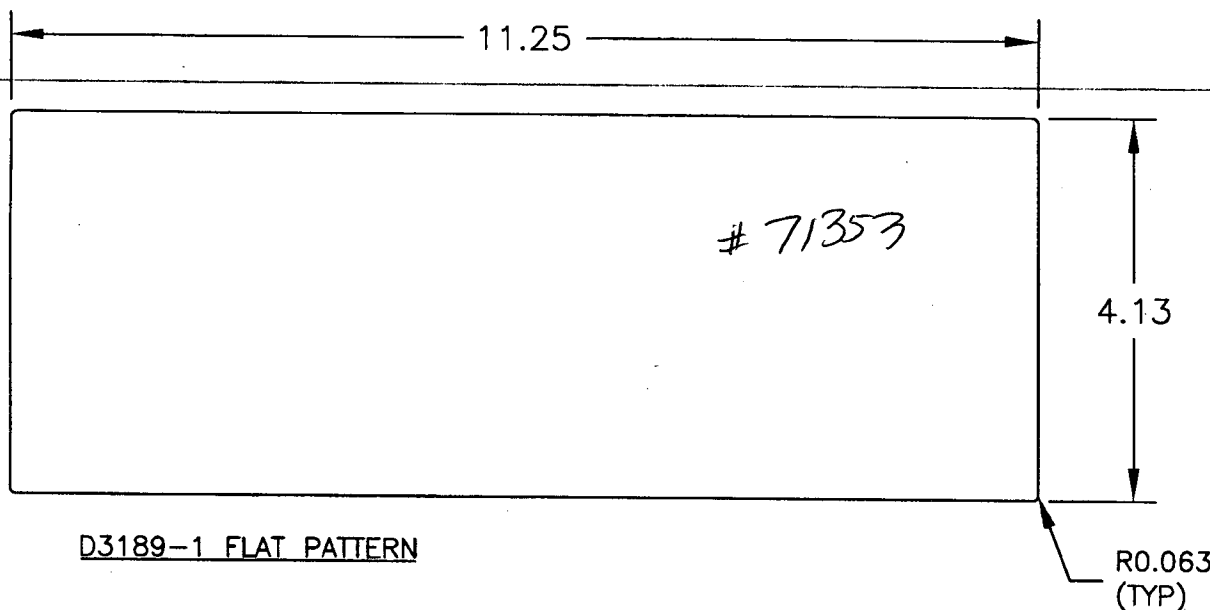
NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D3189	REV. B SHEET 1 OF 2	
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2	
A	03.05.08	NEW ISSUE		
B	07.01.05	ADD -3		

RELEASED

07.03.27



D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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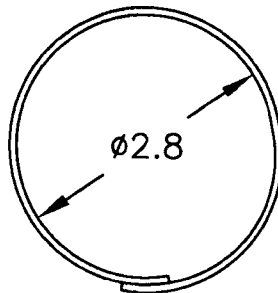
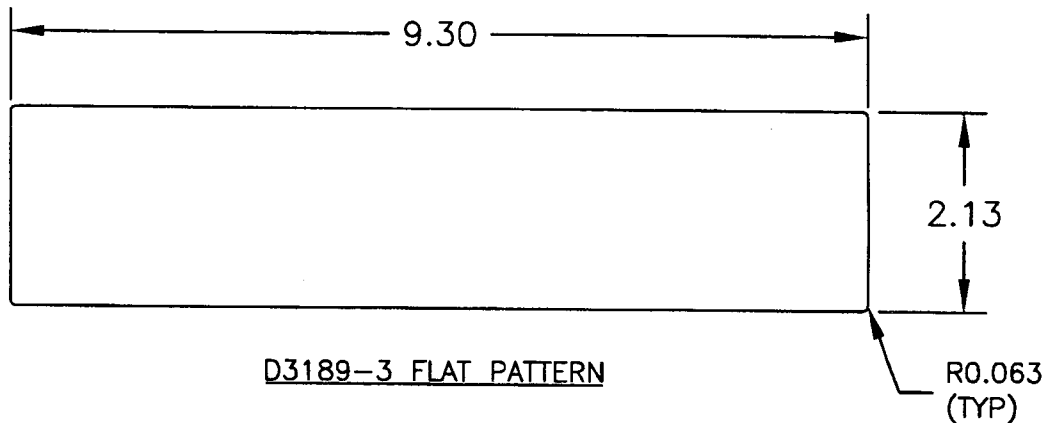
DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 *[Signature]*

#71353



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
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